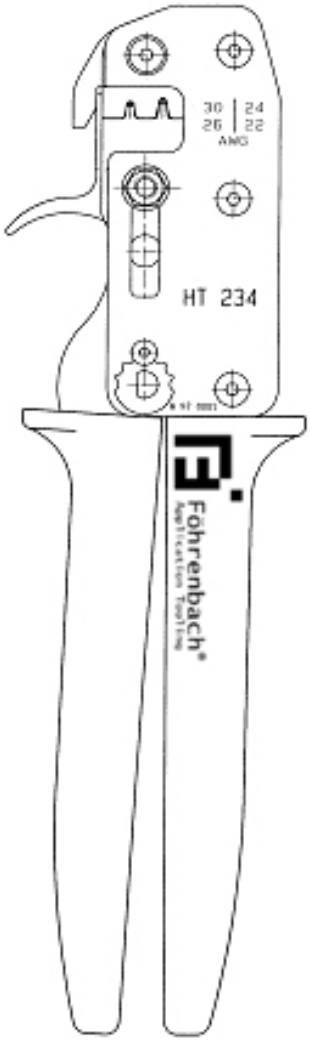
HT234

Handpistol for Dubox

User's guide



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1. DESCRIPTION

The handtool HT 234 is designed to crimp Dubox terminals in the wire range AWG 22-30. The crimper is equipped with two crimp forms, one for wire range AWG 26-30, and one for wire range AWG 22-24. Both are marked at the top of the crimper.

Operation instructions (see figure)

1. Take the handtool in your left hand, so that the movable handle (item 2) and connector fixture (item 30) can be actuated by your thumb.
2. Actuate connector fixture and place terminal in its correct position, touching the wire stop, and with the U-shape facing the crimper.
3. Use wire stripped over a length of 3 ± 0,25 mm.
4. Place the wire into the barrel of the terminal, so that the end of the wire touches the wire stop.
5. Close the handtool by moving the handle (item 1), while wire is held in position.
6. When the handtool is completely closed, the movable handle (item 2) may be returned to its starting position.
7. Finally take the crimped terminal from the handtool.

Note:

The handtool has stops that prevent opening the tool before the crimp action is complete. Should it be necessary, the stop can be released by turning the stop ring (item 9) at the rear side of the tool in the direction indicated by the two yellow arrows. Keep the movable arm under light pressure during this operation.

- Belgium: Föhrenbach Application Tooling NV – Krijgsbaan 128 – 2640 Mortsel
  Tel.: +32 (0)3 216 19 98Fax: +32 (0)3 216 15 07

2. SPECIFICATIONS – PRODUCT INFORMATION

Terminal	:	CTW Dubox (76347-X0X)
Wire range	:	AWG 22-30 (0.05–0.39 mm²)
Crimp height	:	for AWG 22-24: 0.83-0.89 mm
		for AWG 26-30: 0.63-0.70 mm

3. ADJUSTMENTS

Adjustment of Bell Mouth (see figure)

1. Take an open-ended spanner or a ring spanner number 8 (8 mm).
2. Place the spanner around the nut (item 35) on the side opposite the connector fixture (item 30).
3. To increase the bell mouth at the box side of the terminal, the nut (item 35) must be turned to the left.

Note: After adjusting give with a hammer a slight touch on the stud (item 27) to ensure that nut and washer (item 34) are positioned against the cover plate (item 4).

4. To decrease the bell mouth at the box side of the terminal, the nut (item 35) must turned to the right.

Adjustment of crimp height (see figure)
Eventually the crimp height must be readjusted, due to wear of the tool hinges. (For specified crimp heights see below.) Readjusting is done by loosening the screw (item 10) and turning the stop rings (items 9 and 9a) one step, to change the crimp height by approxima-tely 0.05 mm.

Crimp height adjusted by Manufacturer
AWG 22-24: …… **mm**
AWG 26-30: …… Mm

4. MAINTENANCE

- Regular checks must be made for possible gold or tin build-up on crimper and anvil.
- If necessary, these parts must be carefully cleaned.
- Damaged parts must be replaced immediately. For part numbers, see EPL list (5.).
  Because of the coating used on the movable parts of this handtool, oiling of parts is not necessary.

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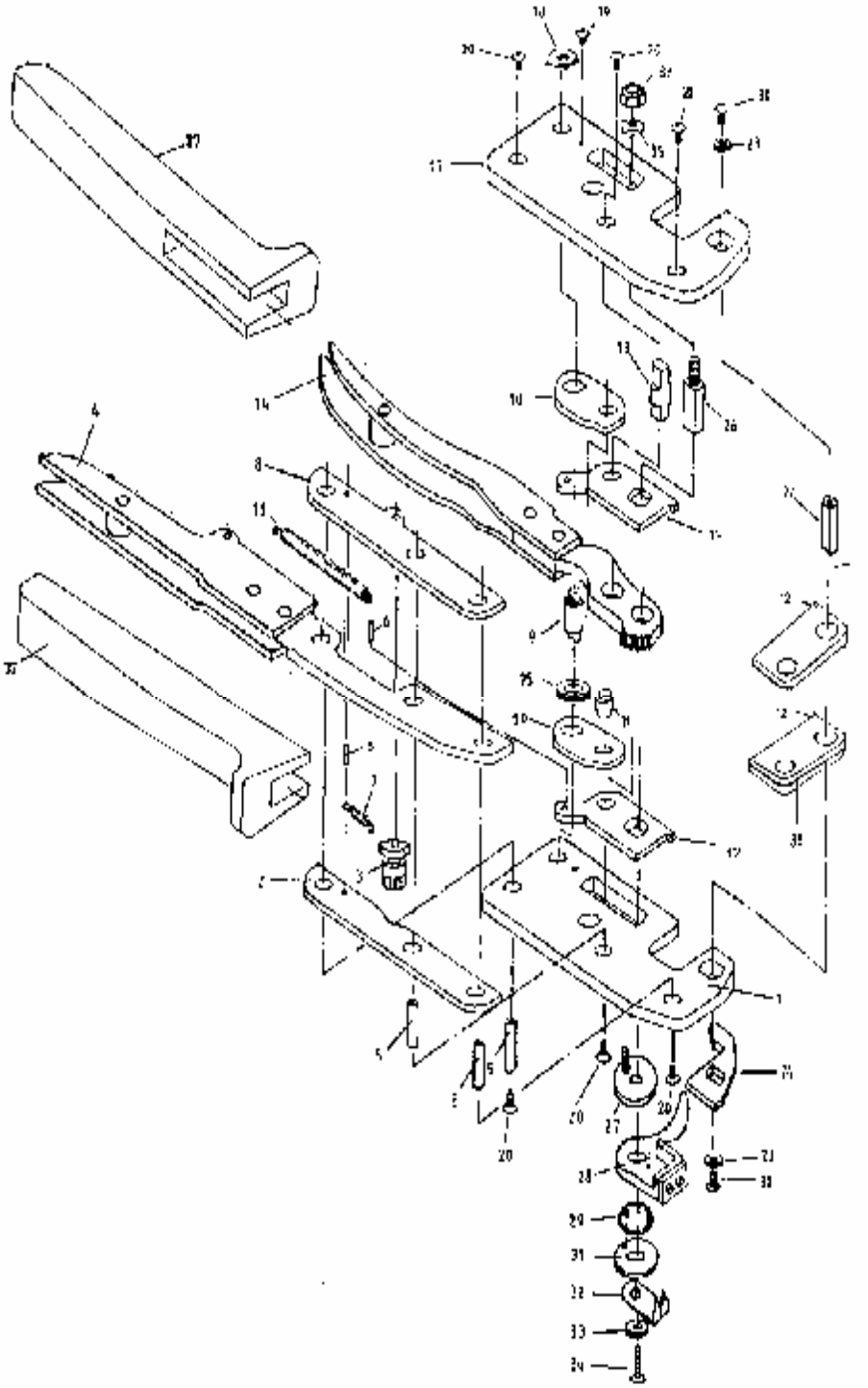
5. PARTS (EPL list) Dubox Handtool HT 234 (Figure 1)

item no	part No	description	qty per assy
1	181026	Cover plate ,lower	1
2	181028	Lower spacer plate	1
3	172391	Pawl	1
4	181027	Handle, permanent	1
5	172397	Connecting pin	3
6	172393	Pin ø2 x 7,1	2
7	172392	Extension spring No 18	1
8	181030	Upper spacer plate	1
9	172389	Eccentric pin	1
10	181003	Connecting plate	2
11	172388	Hinge pin Button head cap screw M3x4	1
12	180692	Crimper & Anvil set	1
13	172395	Guide pin	1
14	173583a	Handle, mobile	1
15	190583	Stop roll	1
16	172394a	Extension spring No 34	1
17	172384a	Cover plate ,upper	1
18	190582	Stopring	1
19	5305-003-050	Button head cap screw M3x4	1
20	5305-003-051	Button head cap screw M4x6	6
22	172399	Thread bush crimper	1
23	173584	Washer B 4.3 DIN 125-ST	2
24	190772	Connector fixture block	1
26	173576	Stud	1
27	181025	Bushing	1
28	181024	Connector fixture	1
29	173579	Torsion spring No 30	1
30	5305-003-051	Button head cap screw M4x6	2
31	173580	Washer	1
32	191587	Wire stop	1
33	190585	Spacer	1
34	5305-003-009	Button head cap screw M4x16	1
35	5310-007-005	Washer B5.3 DIN 125-ST	1
36	5310-001-005	Hex. nut M5	1
37	181011	Plastic grip	2
38	181029	Spacer plate	1
	190116	Pin wrench 2 mm	1
	190117	Pin wrench 2.5 mm	1



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